

**DEPARTMENT OF TRANSPORTATION**

DIVISION OF ENGINEERING SERVICES

Office of Structural Materials

Quality Assurance and Source Inspection



Bay Area Branch  
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Contract #: 04-0120F4Cty: SF/ALA Rte: 80 PM: 13.2/13.9File #: 69.28**WELDING INSPECTION REPORT****Resident Engineer:**Siegenthaler, Peter**Address:** 333 Burma Road**City:** Oakland, CA 94607**Report No:** WIR-021172**Date Inspected:** 22-Sep-2010**Project Name:** SAS Superstructure**OSM Arrival Time:** 700**Prime Contractor:** American Bridge/Fluor Enterprises, a JV**OSM Departure Time:** 1900**Contractor:** Zhenhua Port Machinery Company, Ltd (ZPMC), Changxing Island **Location:** Shanghai, China**CWI Name:** Tian Lei**CWI Present:** Yes No**Inspected CWI report:** Yes No N/A**Rod Oven in Use:** Yes No N/A**Electrode to specification:** Yes No N/A**Weld Procedures Followed:** Yes No N/A**Qualified Welders:** Yes No N/A**Verified Joint Fit-up:** Yes No N/A**Approved Drawings:** Yes No N/A**Approved WPS:** Yes No N/A**Delayed / Cancelled:** Yes No N/A**Bridge No:** 34-0006**Component:** OBG Segment Assembly**Summary of Items Observed:**

On this date Caltrans OSM Quality Assurance (QA) Inspector, Ramesh Gade, was present during the times noted above for observations relative to the work being performed.

This QA Inspector performed the following work:

Bay 2 / Steel Barrier

Flux Core Arc Welding (FCAW) in the 2F position of Steel BarrierE5-SB1C weld # E5-SB1C-003-015. The welder is identified as 045175. ZPMC Quality Control (QC) is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3. See attached photograph Pic\_001.

Bay 3 / OBG Segment 14E

Flux Core Arc Welding (FCAW) in the 2F position of Floor Beam 'I' rib splice weld # FB3260-001-102. The welder is identified as 206623. ZPMC Quality Control (QC) is identified as Zhang Ya Xu. The welding variables recorded by QC appeared to comply with WPS-B-T-2132-3.

Bay 3 OBG Sub Assy14E

Sub Arc Welding (SAW) in the 1G position of Longitudinal Diaphragm plate # X4421A to X4521B splice weld #

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LD3040-001-006. The welder is identified as 050502. ZPMC Quality Control (QC) is identified as Zhang Ya Xu. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2.

## Bay 4 OBG 14E Edge Plate

This QA inspector performed Magnetic Particle (MT) approximately 15% of the area that has been previously tested and accepted by ZPMC Quality Control (QC) personnel. This QA Inspector generated an MT report for this date. The member is identified as Edge Plate as per ZPMC notification # 06732 item # 2.

The weld designations reviewed are as follows:

EP3027-001-014, 017, 019, 095, 096, 108, 109, 021, 022, 023, 024, 025, 026, 027, 028, 029, 030, 031, 032, 033, 034, 035, 036, 053, 054, 055, 056, 057, 058, 059, 060, 061, 064 and 066

Note: - Green Tag # 13132, 13133, 13212 and 13213 signed.

## Bay 2 OBG Sub Assy14W

Sub Arc Welding (SAW) in the 1G position of Longitudinal Diaphragm plate # X4924B to X4925A splice weld # LD3050-001-004. The welder is identified as 207237. ZPMC Quality Control (QC) is identified as Zhu Jun. The welding variables recorded by QC appeared to comply with WPS-B-T-2221-B-L2c-S-2. See attached photograph Pic\_002



## Summary of Conversations:

No relevant conversations reported on this date.

## Comments

This report is for the purpose of determining conformance with the contract documents and is not for the purpose of making repair or fit for purpose recommendations. Should you require recommendations concerning repairs or remedial efforts please contact Eric Tsang (+86)15000 42 2372, who represents the Office of Structural Materials for your project.

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**Inspected By:** Gade,Ramesh

Quality Assurance Inspector

**Reviewed By:** McClendon,Timothy

QA Reviewer